



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2745

Job Sheet 168659



Part No: D2745

Job Qty: 150 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 11/26/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP C 02.03.07 Update to turn in house NG IPP Rev:D 07-10-23 Removed tumbling JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	150 Ea		11/24/17	0.00	0.00	Start Up Machining		<i>17/12/23</i>
100	Hardinge	150 pcs		11/26/17	0.01	10.99	Hardinge		<i>17/12/23</i>
120	QC	150 pcs		11/26/17	0.00	0.00	QC8		<i>17-12-27</i>
130	Packaging	150 pcs		11/26/17	0.00	0.00	Packaging3 <i>SB FP001</i>		<i>17-12-27</i>
140	QC21-SA	150 Ea		11/26/17	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg D2515

Descriptions: 130 - LOCATION : FP001

JAN 02 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.750	14	62	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.060inches ± 0.010	0.070 0.050		
2	Bushing	0.400inches ± 0.010	0.410 0.390		
3	Bushing	0.060inches ± 0.010	0.070 0.050		
4	Bushing	1.020inches ± 0.010	1.030 1.010		
5	Bushing	0.030inches ± 0.010	0.040 0.020		
6	Bushing	20.000Degrees ± 0.000	20.000 20.000		
7	Bushing	0.472inches ± 0.010	0.482 0.462		
8	Bushing	0.375inches + 0.006 - 0.001	0.381 0.374		
9	Bushing	0.560inches ± 0.010	0.570 0.550		
10	Bushing	0.750inches ± 0.010	0.760		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



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CANADA
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PART NO: D2745
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/23/17
Job No: 168659

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐
Part No. _____		
NCR No. _____		
Date: _____		Step #: _____ QTY Effective: _____

Description Work Order Deviation

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/U ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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FAU

Misaligned/off center	Finish
Fit/Function	Misread
	Turning Sequence



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D2745 Revision: Bushing														
140	QC21-SA	S026936	168659	150 Ea	0	S026936	FP001	Bin	Stock	12/23/2017	Issue Container			
Operation Totals:		1		150	0									
Part Totals:		1		150	0									
Part Number: M303R0.750 Revision: 303 Round Bar 0.750														
100	Receive Ft	S026934	168659	4 ft	0		Start Up Machining		Stock	12/23/2017	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Totals:		2		154	0									

Plex 1/8/2018 8:08 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					